

Work Order ID 62363

Tuesday, September 28, 2010 11:47:10 AM

Page 1

Item ID: PB67-43001-11

Accept

Setup Start

Revision ID:

Stop

Item Name: Fwf Adjustable Blade Support Assembly

Start Date: 9/29/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 10/6/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: *mf* Date: *10-9-08*

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

B67-43001-11

Rev C

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- make a 0.090" chamfer in the 1.00" hole before welding □ 2- assemble parts and weld as per dwg

10.10.05

1

110

OK

QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

120



QC

QC5- Inspect part completeness to step on W/O 0.00

Memo

0.00

Quality Control

12

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Cust Item ID:

Required Date: 10/6/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
105 <i>E</i>	Small Fab <i>Lng Fab E</i>	0.00							
Small Fab	Memo	0.00							
Small Fab	1- grind weld flush in area of PB67-43001-249 only 2- install helicol insert as per dwg								
140	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
150	Chemical Conversion Coat per QS1005 4.1	0.00							
HandFinish	Memo	0.00							
Hand Finishing									

10.10.05 *1* *P*

QC9 - 1 PD 10.10.05
QC5 Sid 10.10.06 *⊕*

N/A E 10.10.05

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Green Sandtex(Ref:4.3.5.8) per QSI005 4.3

0.00

10-10-6



Powdercoat

Memo

0.00

Powder Coating

1- MASK TUBE FROM BASE TO GUSSET START TIME:
1:40 OVEN TEMPERATURE: *300°* FINISH
TIME: *2:10*

①

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

=> 10/10/4

1 ①

180

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1- match drill cover to existing holes in support 2- assemble as per dwg

10-10-14

1 ①

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Start Date: 9/29/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 10/6/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

200

Identify as per dwg & Stock Location: WA

0.00



Packaging

Memo

0.00

Packaging

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/14

Picklist Print

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Work Order ID: 62363

Parent Item: PB67-43001-11

Parent Item Name: Fwf Adjustable Blade Support Assembly

Start Date: 9/29/2010

Required Date: 10/6/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-06-26 new issue DD verified by:ec
10.09.27 per revC dwg EC verified by:DD

IPP Rev B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS124780 HELICAL INSERT		Purchased	No			180	Each	142.0000	1	1		10.10.05	

Location Loc Qty Loc Code

ST314 142

111064 142

MS27039-1-10 Screw		Purchased	No			180	Each	117.0000	8	8		10.10.14	
-----------------------	--	-----------	----	--	--	-----	------	----------	---	---	--	----------	--

Location Loc Qty Loc Code

ST291 117

112794 17

112940 100

NAS1149D0316J Washer		Purchased	No			180	Each	0.0000	8	8		10.10.14	319600
-------------------------	--	-----------	----	--	--	-----	------	--------	---	---	--	----------	--------

3 AN9601DIOLL

NAS1149D0363J Washer		Purchased	No			180	Each	2,907.000	8	8		10.10.14	
-------------------------	--	-----------	----	--	--	-----	------	-----------	---	---	--	----------	--

Location Loc Qty Loc Code

ST298 2907

114292 114

114884 41

115107 27

115622 2716

9221 9

Picklist Print

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Work Order ID: 62363

Parent Item: PB67-43001-11

Parent Item Name: Fwf Adjustable Blade Support Assembly

Start Date: 9/29/2010

Required Date: 10/6/2010

Start Qty: 1.00

Required Qty: 1.00

PB67-43001-247

Manufactured No

100

Each

2.0000

1

1



Inner Tube



10.10.05

Location

Loc Qty

Loc Code

ST446

2

44985

2

PB67-43001-249

Manufactured No

100

Each

11.0000

1

1



Inner Tube Bushing



10.10.05

Location

Loc Qty

Loc Code

ST438

11

52480

11

PB67-43001-253

Manufactured No

100

Each

4.0000

1

1



Gusset



10.10.05

Location

Loc Qty

Loc Code

ST438

4

44983

4

PB67-43001-254

Manufactured No

100

Each

24.0000

1

1



Gusset



10.10.05

Location

Loc Qty

Loc Code

ST438

24

52481

24

PB67-43001-67

Manufactured No

130

Each

2.0000

1

1



PB67-43001-67



10.10.05

Location

Loc Qty

Loc Code

ST446

2

52634

2

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Shop Packet Print

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Picklist Print

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Parent Item: PB67-43001-11



Parent Item Name: Fwf Adjustable Blade Support Assembly

Start Date: 9/29/2010

Required Date: 10/6/2010

Start Qty: 1.00

Required Qty: 1.00

PB67-43001-69

Manufactured No

180

Each

5.0000

1

1



90 Degree Cover Plate



PK 10.10.14

Location

Loc Qty

Loc Code

ST444

5

52433

5

1

PB67-43001-83

Manufactured No

180

Each

6.0000

1

1



PK 10.10.14

PB67-43001-83

Location

Loc Qty

Loc Code

ST445

6

52418

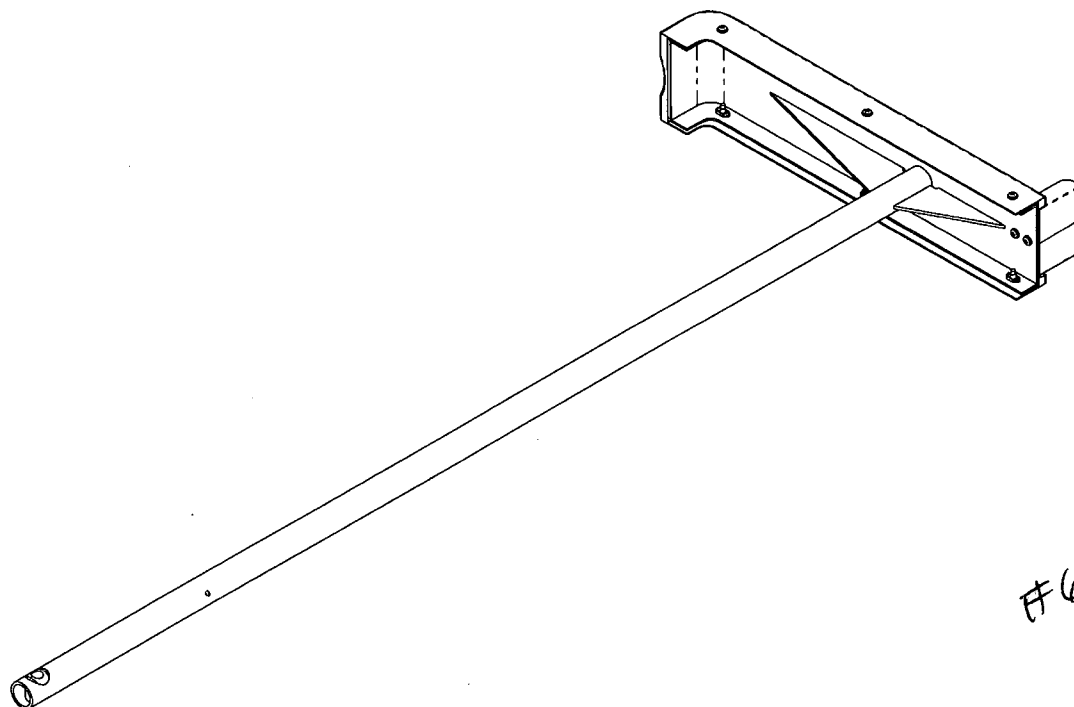
6

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Shop Packet Print

Page 3



B67-43001-11 FWD ADJUSTABLE BLADE SUPPORT ASSY

ITEM	QTY -11	P/N	DESCRIPTION
1	X	B67-43001-11	FWD ADJUSTABLE BLADE SUPPORT ASSEMBLY
2	1	B67-43001-11W	FWD ADJUSTABLE BLADE SUPPORT WELDMENT
3	1	B67-43001-69	90° COVER PLATE ASSEMBLY
4	1	B67-43001-83	SHORT D-PAD ASSY
5	8	MS27039-1-10	SCREW
6	8	NAS1149D0316J	WASHER
7	6	NAS1149D0363J	WASHER

#62363

RELEASED
2010-09-16
NM

C		REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 8 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	10.04.28
REV.		DESCRIPTION	BY	DATE	
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. B67-43001-11 TITLE FWD ADJUSTABLE BLADE SUPPORT ASSY		REV. C	
DRAWN				SHEET 1 OF 2	
CHECKED				SCALE	
MFG. APPR.				NTS	
APPROVED					
DE APPR.	N/A				
DATE	10.04.28				

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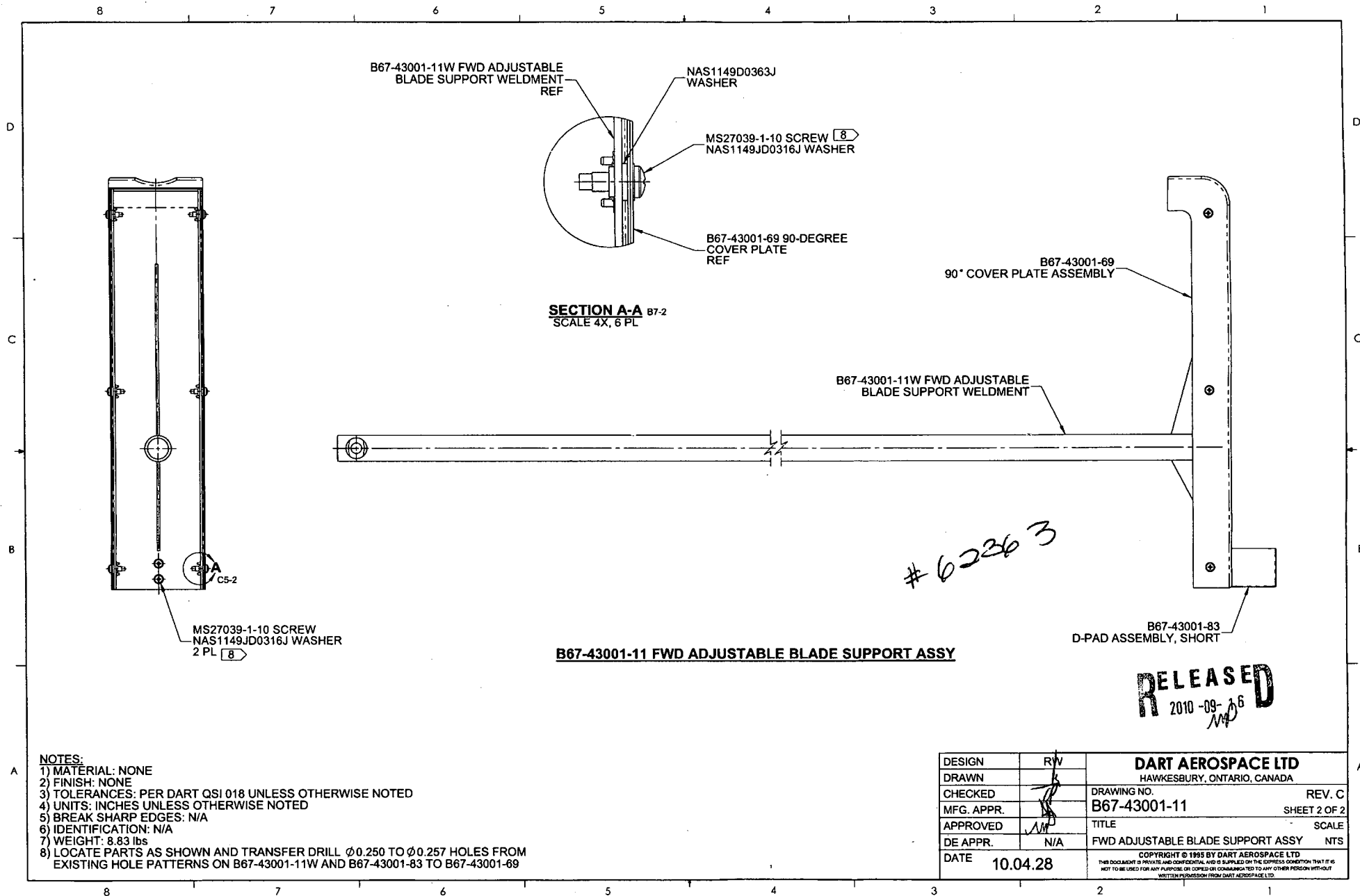
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

B67-43001-11W FWD ADJUSTABLE BLADE SUPPORT WELDMENT

ITEM	QTY -11W	P/N	DESCRIPTION
1	X	B67-43001-11W	FWD ADJUSTABLE BLADE SUPPORT WELDMENT
2	1	B67-43001-67	90-DEGREE BLADE SUPPORT ASSY
3	1	B67-43001-247	INNER TUBE
4	1	B67-43001-253	GUSSET
5	1	B67-43001-254	GUSSET
6	1	B67-43001-249	INNER TUBE BUSHING
7	1	MS124780	HELICAL INSERT

#62363

RELEASED
2010-09-15

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 8 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	10.04.28
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. B67-43001-11W REV. C TITLE FWD ADJUSTABLE BLADE SUPPORT WELDMENT SCALE NTS		
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED		DATE 10.04.28		
DE APPR.	N/A	<small>COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		

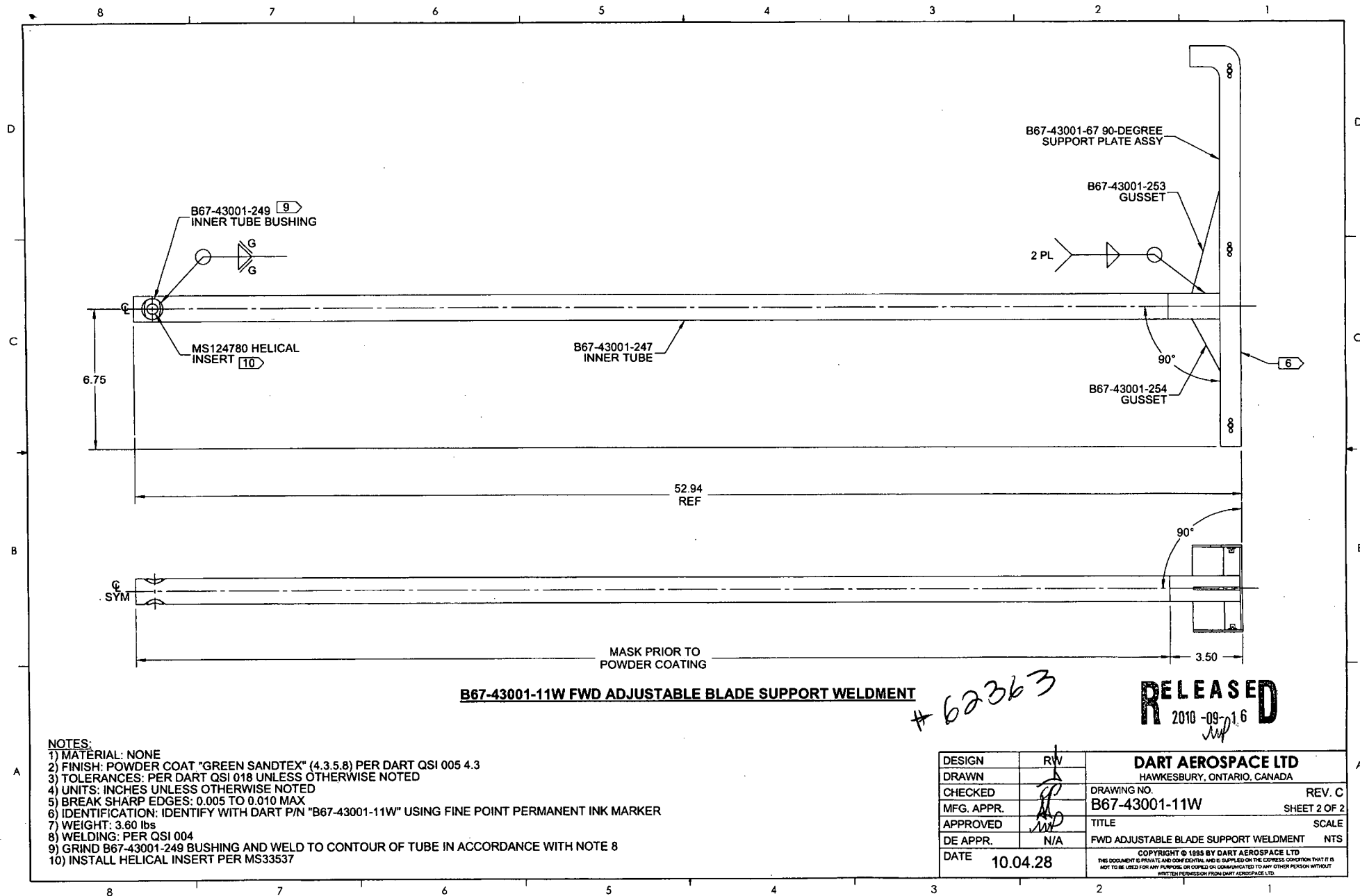
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 2010-09-16

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